

Work Order ID 161414

161414

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Monday, May 15, 2017 1:53:20 PM

Item ID: 644.4118 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Washer, Nylon
 Start Date: 5/23/2017 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 6/2/2017 Req'd Qty: 24.00 *24* Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan:  Date: MAY 16 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
644.4100	F2								
100	FLOW WATER JET	0.11							
100									
Waterjet	Memo	0.72							
FLOW CNC Waterjet	***CUT WITHOUT ABRASIVE***								
	1-Cut as per Dwg								
	Dwg Rev: F2								
	Prog Rev: F2								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.24							
Quality Control									

(24)

05/17/17

(24)

05/17/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

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Approvals: Process Plan:  Date: MAY 16 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.48				24			DAS 38 9-89 MAY 18 2017
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>CCK131</u> Memo <u>LOCATION: GA</u>	0.00 0.24				24	DAS 6 9-89		MAY 18 2017
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 2.40							17/5/18   MAY 18 2017

DQA: _____ Date: _____



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Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
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Misidentified ☐	☐	Past Due								

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Parent Item: 644.4118

644 4118

Parent Item Name: Washer, Nylon

Start Date: 5/23/2017

Required Date: 6/2/2017

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A NEW ISSUE 16-12-06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8555K999		Purchased		No		100	sf	3.0000	0.02755	0.696			

8555K999

Self-Lubricating MDS-Filled Nylon Sheet 1/32" x 12" x 24"

**

217/05/17

Location

Loc Qty

Loc Code

ST

3

m136379

3

1

DQA: _____ Date: _____



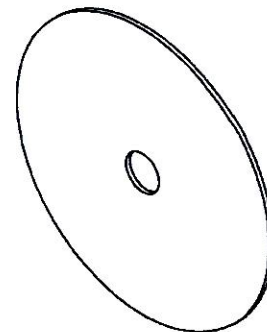
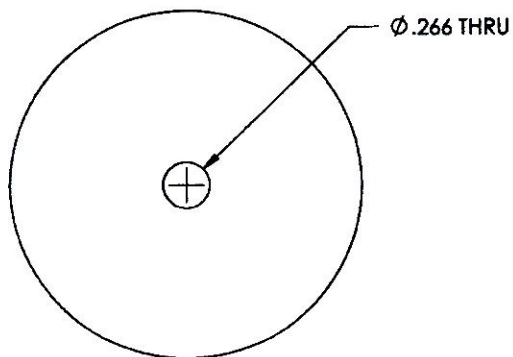
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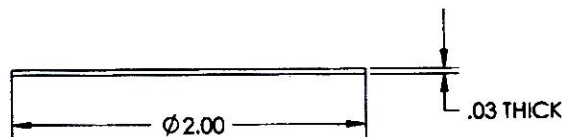
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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161414

MAY 16 2017



644.4118
WASHER, NYLON

ORIGINAL DATE 09-01-05	APICAL INDUSTRIES		
DRAWN BY D. PARRISH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
DRAWING APPROVAL L. JOHNSON 05-29-05	PIVOT STEP ASSY		
CONTRACT NO.	REV. 1 CASE CODE 07M16	REV. 2 CASE CODE 07M16	REV. 3 CASE CODE 07M16
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ± .010 2 PLACE DECIMALS ± .005 ANGLES ± .5°	SCALE NONE	SHEET 10 OF 14	